

Date: Friday, 02/05/2008 11:55:52 AM
 User: Julie Lecocq

Process Sheet

| | | | |
|------------------------------------|--|---------------------------|---------------------------|
| Customer : | CU-DAR001 Dart Helicopters Services | Drawing Name : | CABIN DOOR ROLLER KIT, LH |
| Job Number : | 39006 | | |
| Estimate Number : | 10276 | | |
| P.O. Number : | | Part Number : | D412698011 |
| This Issue : | 02/05/2008 | S.O. No. : | |
| Prsht Rev. : | NC | Drawing Number : | IIN D412-698 REVD |
| First Issue : | 02/05/2008 | Project Number : | N/A |
| Previous Run : | 38979 | Drawing Revision : | D |
| Written By : | | Material : | |
| Checked & Approved By : | <u>JLD 08.502</u> | Due Date : | 20/05/2008 |
| Comment : | Est Rev:C 04.02.26 Change Qty of D3121-141 & remove D3121-145 from Step 1,3 KJ/DS Est Rev:D 08-01-28 change to rev D ECN 1104 DD | | |
| Qty: | 4 | Um: | Each |

Additional Product

Job Number:



| Seq. #: | Machine Or Operation: | Description : |
|---------|-----------------------|---------------|
|---------|-----------------------|---------------|

| | | |
|-----|----|------------------|
| 1.0 | DC | DOCUMENT CONTROL |
|-----|----|------------------|



Comment: DOCUMENT CONTROL

Photocopy bluefile and create labels per PPP D412-698-011 CHG003

5 02/05/28 08.5.06 JLD

| | | |
|-----|-------------|-----------------------|
| 2.0 | PACKAGING 1 | PACKAGING RESOURCE #1 |
|-----|-------------|-----------------------|



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

| | | |
|-----|----------|------------------|
| 3.0 | D3121141 | Bracket Assembly |
|-----|----------|------------------|



Comment: Qty.: 3.0000 Each(s)/Unit Total : 12.0000 Each(s)

Pick: Packing Kit

| | | |
|-----------------|------------------|--------------|
| Qty Part Number | Description | Batch |
| 3 D3121-141 | Bracket Assembly | <u>39324</u> |

| | | |
|-----|----------|------------------|
| 4.0 | D3121143 | Bracket Assembly |
|-----|----------|------------------|



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick: Packing Kit

| | | |
|-----------------|------------------|--------------|
| Qty Part Number | Description | Batch |
| 1 D3121-143 | Bracket Assembly | <u>39014</u> |

| | | |
|-----|----------|------------------|
| 5.0 | D3137043 | Bracket Assembly |
|-----|----------|------------------|



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick: Packing Kit

| | | |
|-----------------|-------------|--------------|
| Qty Part Number | Description | Batch |
| | | <u>29725</u> |

PC 8/27 (4)

Dart Aerospace Ltd

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

Date: Friday, 02/05/2008 11:55:52 AM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: CABIN DOOR ROLLER KIT, LH

Job Number: 39006

Part Number: D412698011

Job Number:



Seq. #:

Machine Or Operation:

Description:

1 D3137-043 Bracket Assembly

6.0

D3183043

Bracket Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description

Batch

1 D3183-043

Bracket Assembly

37672

2X New Batch
Not in comp yet

B38982 x2

7.0

D31991

Bracket



Comment: Qty.: 9.0000 Each(s)/Unit Total: 36.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description

Batch

9 D3199-1

Bracket

39079 35X

341515 1X

8.0

D32021

Cover



Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description

Batch

1 D3202-1

Cover

38445

PC 8/0/27 (4)

9.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

S 08/05/28 28 (4)

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D412-698-011

Location:

Rev B

PS 8/05/28 (4)

11.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/05/29 (4)

Job Completion



MF 08-05-28

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

6.0 PARTS LIST

| Qty -011 | Qty -012 | Qty -013 | Qty -015 | Qty -017 | Qty -019 | Qty -021 | Part Number | Description |
|-------------|-------------|-------------|-------------|-------------|-------------|-------------|--------------|----------------------------|
| X | | | | | | | D412-698-011 | CABIN DOOR ROLLER KIT, LH |
| | X | | | | | | D412-698-012 | CABIN DOOR ROLLER KIT, RH |
| | | X | | | | | D412-698-013 | DOOR HANDLE KIT |
| | | | X | | | | D412-698-015 | DOOR SUPPORT KIT |
| | | | | X | | | D412-698-017 | REPLACEMENT DOOR TRACK KIT |
| | | | | | X | | D412-698-019 | BEARING OVERHAUL KIT |
| | | | | | | X | D412-698-021 | REPLACEMENT SHIM KIT |
| | | | | | | 7 | D3121-21 | BOLT |
| | | | | | 5 | | D3121-241 | BEARING ASSEMBLY |
| 3 | 3 | | | | | | D3121-141 | BRACKET ASSEMBLY |
| 1 | | | | | | | D3121-143 | BRACKET ASSEMBLY |
| | 1 | | | | | | D3121-144 | BRACKET ASSEMBLY |
| | | | | | 1 | | D3137-3 | GUIDE |
| | | | | | 1 | | D3137-5 | WASHER |
| 1 | 1 | | | | | | D3137-043 | BRACKET ASSEMBLY |
| | | | | | 2 | | D3183-045 | BEARING ASSEMBLY |
| 1 | | | | | | | D3183-043 | BRACKET ASSEMBLY |
| | 1 | | | | | | D3183-044 | BRACKET ASSEMBLY |
| 9 | 9 | | | 9 | | | D3199-1 | BRACKET |
| 1 | 1 | | | 1 | | | D3202-1 | COVER |
| | | 4 | | | | | D3203-1 | HANDLE |
| | | 1 | | | | | D3220-041 | DOUBLER |
| | | 1 | | | | | D3220-042 | DOUBLER |
| | | 2 | | | | | D3220-3 | DOUBLER |
| | | | 2 | | | | D3200-1 | DOOR POST BLOCK |
| | | | 2 | | | | D3200-3 | DOOR WEDGE |
| | | | 2 | | | | D3201-1 | DOUBLER |
| | | | 1 | | | | D3201-3 | ANGLE |
| | | | 1 | | | | D3201-4 | ANGLE |
| | | | | | | 3 | D3238-1 | SHIM |
| | | | | | | 1 | D3238-3 | SHIM |
| | | | | | | 2 | D3238-5 | SHIM |
| | | | | | | 6 | D3238-11 | SHIM |
| | | | | | | 2 | D3238-13 | SHIM |
| | | | | | | 4 | D3238-15 | SHIM |
| | | | 12 | | | | AN960JD10L | WASHER |
| | | 8 | | | | | AN960JD416L | WASHER |
| | | | 12 | | | | MS21042L3 | NUT (OR MS21042-3) |
| | | 8 | | | | | MS21042L4 | NUT (OR MS21042-4) |
| | | 16 | | | | | MS24694-S98 | SCREW |
| | | | | | 1 | | MS24694-S101 | SCREW |
| | | | 12 | | | | MS24693-S277 | SCREW |

(CONTINUED ON PAGE 15)

• COPYRIGHT © 2003 BY DART AEROSPACE LTD. •
 THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED
 OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

Revision: D

Date: 07.07.03

SHOP COPY

RETURN TO

ENGINEERING

UNCONTROLLED COPY

SUBJECT TO AMENDMENT

WITHOUT NOTICE

WORK ORDER

NO. 37000